

# Work Order ID 58162

April 26, 2010 3:26:32 PM



Page 1

Item ID: D3752-1

Accept



Setup Start



Revision ID:

Item Name: Seat Frame

Stop



Start Date: 26/04/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 04/05/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *AL*

Date: *10-4-26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

*OK 10/04/26 (X3)*  
*PTO, →*

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240°F*

*OK 10/04/26*

Time IN: *4:00 pm.*

*OK 10/04/26*

Time OUT: *7:00 am*

*B 10/04/27*

*OK 10/04/26 (X3)*

W/O: 58162		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/27	100-	NOTE: Mould WAS REWORKED PRIOR TO THERMOFORMING PARTS. Height of the back rest was lengthened. to conform to drawing. First part off was used to verify fit.	0/0	10/04/27.		10.04.27	S 10/04/28

Part No: D3752-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 58162

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Page 2

Item ID: D3752-1

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3752 and folio (FTA022 ) using tool DT 8997

Dwg. Rev. C  
Folio Rev. B

\_\_\_\_\_  
\_\_\_\_\_  
10/04/27 (X3)

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_  
\_\_\_\_\_  
10/04/27 (X3)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_  
\_\_\_\_\_  
10/04/27 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O: 58162		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/20	160	Keep 1 unit for R+D lab.	WJH	10/04/20	1	A 10.04.20	

Part No: D 3752-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Work Order ID 58162

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Item ID: D3752-1

Accept



Setup Start



Revision ID:

Item Name: Seat Frame

Stop



Start Date: 26/04/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 04/05/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location 25/A

0.00



Packaging

Memo

0.00

Packaging

10-4-29 (24) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30 98

MF  
10-4-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

April 26, 2010 3:26:36 PM

Page 1

Work Order ID: 58162



Parent Item: D3752-1



Parent Item Name: Seat Frame

Start Date: 26/04/2010

Required Date: 04/05/2010

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD  
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C  
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105  
Dry Material 10/04/21 DL

Start Qty: 3.00

Required Qty: 3.00

MLEXS.125-F60029-04

Purchased

No

100

sf

2,635.532 32.0010



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2635.5328

111710

64

112585

224

114032

2347.5328

162585

Dh, 10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	58142
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: Sh. Date: 10/04/27

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.029	✓			
0.035	Min	0.049"	✓			
0.040	Min	0.057	✓			
0.075	Min	0.101"	✓			
0.052	Min	0.084"	✓			
0.021	Min	0.0244	✓			
0.036	Min	0.055"	✓			

Measured by: Sh. Date: 10/04/27

Audited by: JB Date: 10/04/27

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

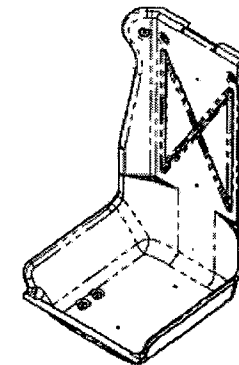
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

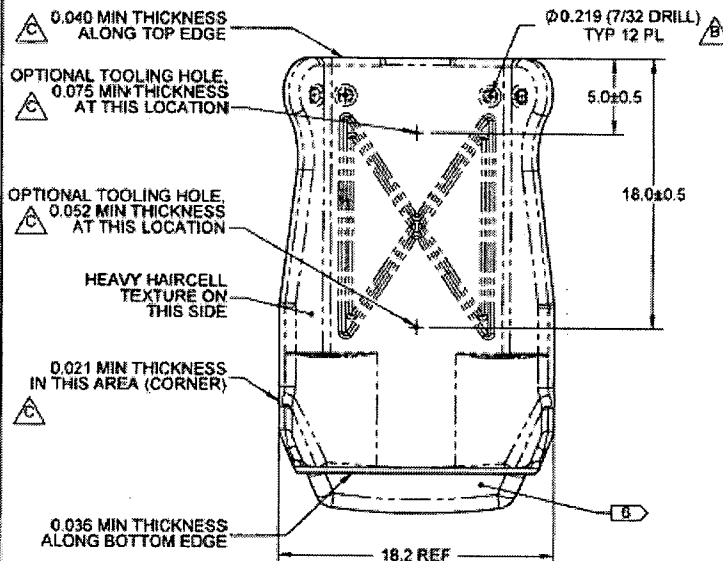
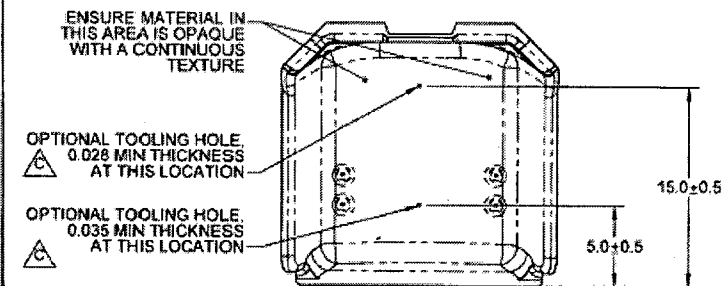
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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58102  
*R/10-4-25*



RELEASED  
08/11/05



**D3752-1 SEAT FRAME**

**NOTES:**

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

C	REDUCE THICKNESS: 0.040 WAS 0.050 (Z1 C8-1), 0.075 WAS 0.100 (C8-1), 0.052 WAS 0.090 (B8-1), 0.021 WAS 0.030 (B8-1), 0.038 WAS 0.060 (A8-1), 0.028 WAS 0.035 (D8-1), 0.036 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1)	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1). 18.0 WAS 19.8 (C4-1). 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3752** REV. C  
TITLE **SEAT FRAME** SHEET 1 OF 1  
SCALE NTS

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